

5/03

DART AEROSPACE LTD	Work Order:	22080
Description: Doubler/ Mount Angle/ Filler	Part Number:	D3208-1/-3/-7
Dwg: D3208 Rev. A page 1, 2	Qty:	4
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler 04.06.08 Note: To be made in multiples of 10- Dwg not required	<i>[Signature]</i>	04.12.08	4
2	GA	Cut blank: 4.038" X 5.340" grain along 4.038" Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Identify for D3208-1 Batch: <i>M16302</i>	CPL	04-12-15	4
3	GA	Cut blank: 2.750" x 4.300" Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Identify for D3208-7 Batch: <i>M16302</i>	CPL	04-12-15	4
4	GA	Cut blank: 1.651" x 5.250" grain along 1.651" Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) <i>M15510</i> Identify for D3208-3 Batch: <i>M15510</i>	CPL	04-12-15	4
5	GA	Drill and Fillet D3208-1 corner as per Dwg D3208 Identify as D3208-1	CPL	04-12-15	4
6	GA	Drill and Fillet D3208-7 corner as per Dwg D3208 Identify as D3208-7	CPL	04-12-15	4
7	GA	Drill and Fillet D3208-3 corner as per Dwg D3208 Identify as D3208-3	CPL	04-12-15	4
8	GA	Deburr D3208-1/-3/-7	CPL	04-12-15	4
9	GB	Form D3208-1 as per Dwg D3208	<i>[Signature]</i>	05-01-05	4
10	GB	Form D3208-3 as per Dwg D3208	<i>[Signature]</i>	05-01-05	4
11	QC5	Inspect work to Step 10	<i>[Signature]</i>	05-01-10	4
12	FP	Chemical Conversion Coat as per QSI 005 4.1	<i>[Signature]</i>	05-01-11	4
13	QC3	Inspect Conversion Coat	<i>[Signature]</i>	05-01-11	4
14	ST	Identify and Stock D3208-1 Qty: <u>4</u> D3208-3 Qty: <u>4</u> D3208-7 Qty: <u>4</u>	CPL	05/01/11	4
15	AC	Parts to Stock and Prorate cost to parts per Step 20 Cost / part <u>14.46</u> <u>14.21</u> <u>14.12</u>	<i>[Signature]</i>	05-01-12	4
16	DC	Close W/O <u>7.80</u> <u>7.34</u> <u>7.47</u> Inspect Level 21	<i>[Signature]</i>	05.01.12	4

Rev	Date	Change	Revised By	Approved
A	04.04.15	New issue	KJ/RF	
B	04.05.25	Material changed for Step 4	KJ/JLM	<i>[Signature]</i>

RELEASED

06/04/05.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 06, 2004
11:09 am

Work Order No : 0022080
Project Name : D3208-7
Project For : WK503
Work Order Type : Main
Main WO Number :
House Part Number : D3208-7
Description : Filler
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 12-06-04
Est Finish Date : 01-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

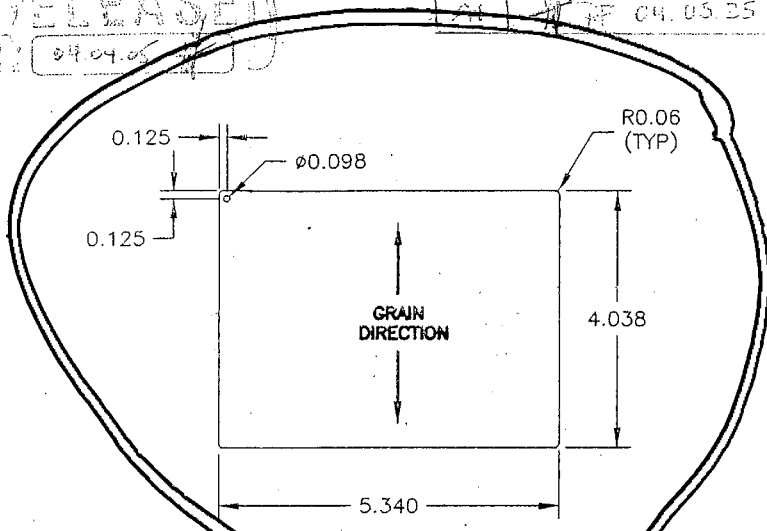
	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART
CONTROLLED COPY

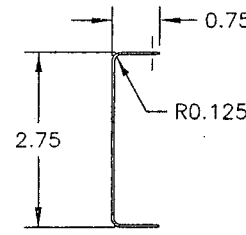
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CHECKED #	APPROVED #	DRAWING NO. D3208	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE DOUBLER	SCALE 1:3	

A	04.01.27	NEW ISSUE
AI	04.05.25	CHANGE DIM, NOTE 3) CHANGE

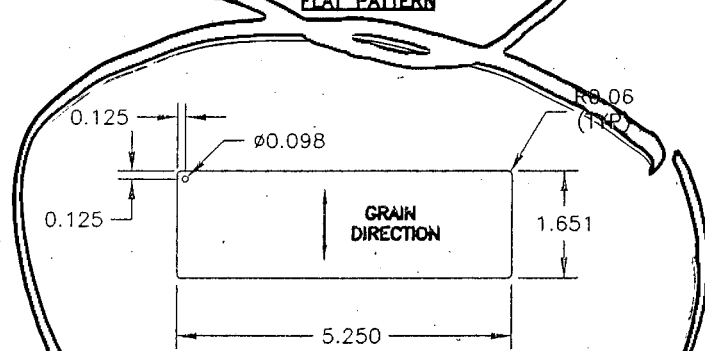
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04.04.06



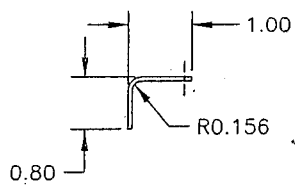
**D3208-1 DOUBLER
FLAT PATTERN**



**D3208-1 DOUBLER
BEND DETAIL**



**D3208-3 PEDAL MOUNT ANGLE
FLAT PATTERN**



**D3208-3 PEDAL MOUNT ANGLE
BEND DETAIL**

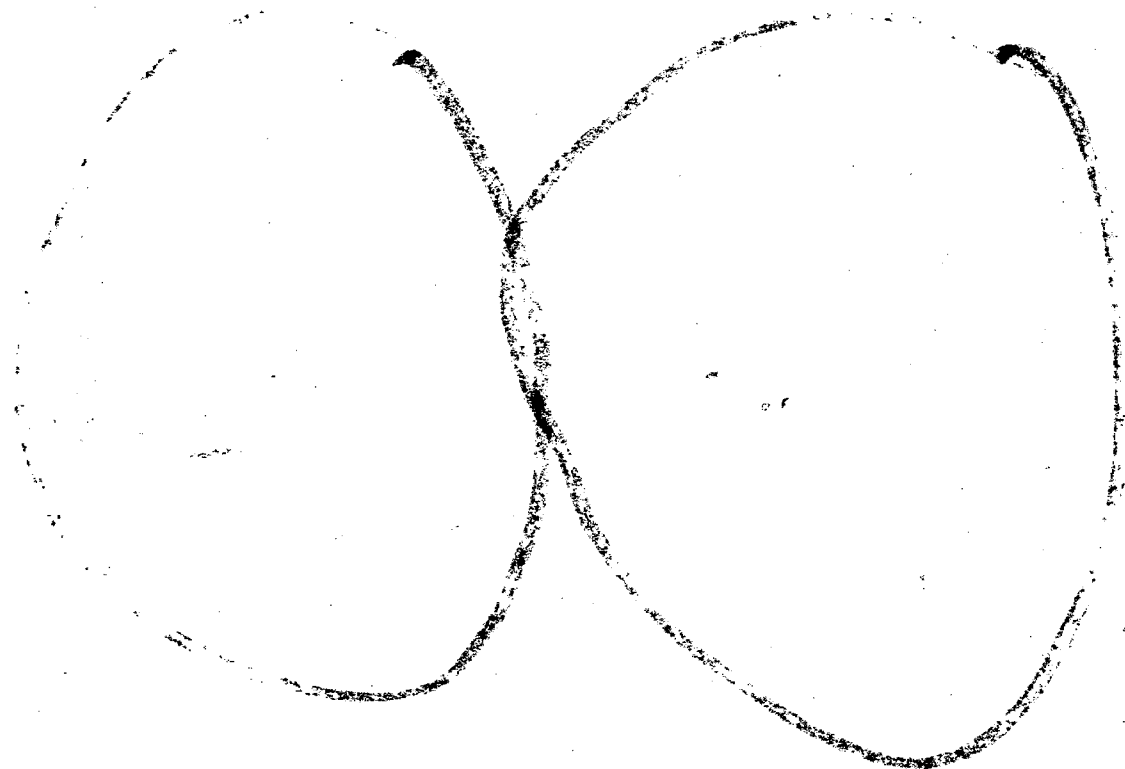
NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)

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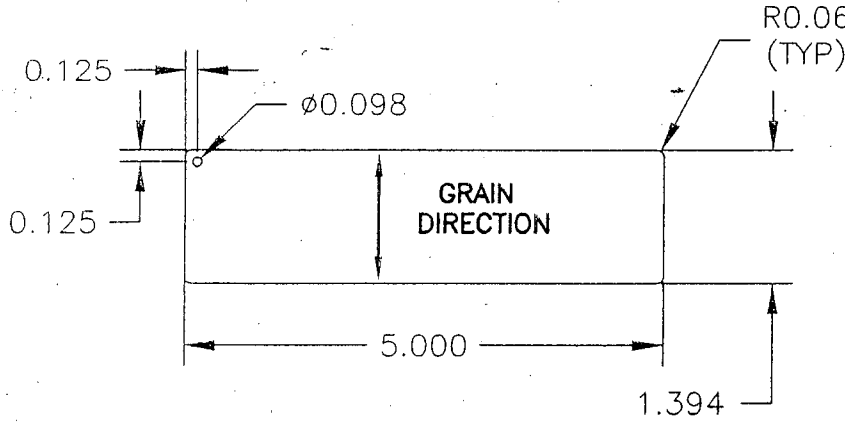


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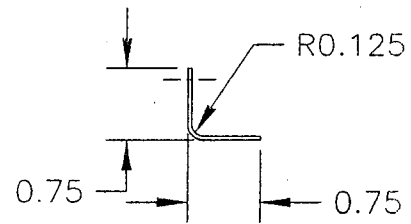


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3208	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

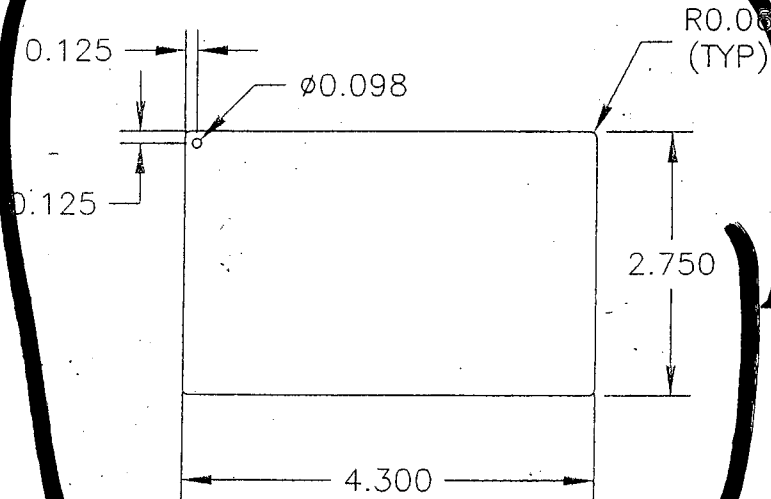
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04.04.05



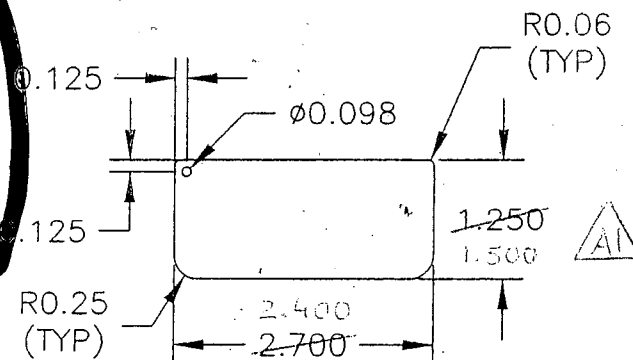
2 D3208-5 MOUNT ANGLE
FLAT PATTERN



D3208-5 MOUNT ANGLE
BEND DETAIL



2 D3208-7 FILLER



2 D3208-11 FILLER

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